

Date: Friday, 31/10/2008 10:20:16 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BATTERY LOCK CASHING
Job Number : 43123	
Estimate Number : 10474	
P.O. Number :	Part Number : D33931
This Issue : 31/10/2008 S.O. No. :	Drawing Number : D3393 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 38333	Material :
Written By :	Due Date : 15/11/2008 Qty: 15 Um: Each
Checked & Approved By : <u>JLD 08.10.31</u>	
Comment : Est. A 05.02.18 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01500	6061-T6 Bar 1.50 x 1.50
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Comment: Qty.: 0.2843 f(s)/Unit Total : 2.8434 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6B1.500x01.500)

Batch: M108362

28 08/11/01

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank: 1.500" x 1.500" x 3.125" long

Machine D3393-1 as per Folio FA510 and Dwg D3393

Identify as D3393-1

Deburr

28 08/11/01

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

28 08/11/03

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

28 08/11/03

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FZ 08/11/04

(15)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 31/10/2008 10:20:17 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK CASHING

Job Number: 43123

Part Number: D33931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M18052



15x

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15
320°F
8:45

MF 08/11/05

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



15

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/11/05

8.0

PACKAGING 1

PACKAGING RESOURCE #1



15x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

488

8/11/05

20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43123
Description: Battery Lock Casing		Part Number: D3393-1
Inspection Dwg: D3393	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

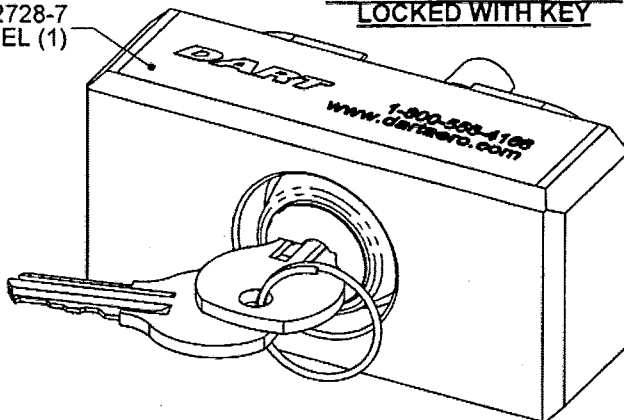
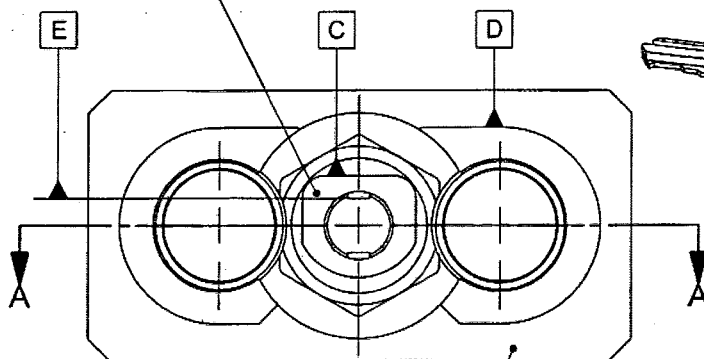
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	±0.010 ^{+0.010} -0.010	.752				
0.625	±0.010 ^{+0.010} -0.010	.630				
Ø1.250	±0.010 ^{+0.010} -0.010	1.248				
1.088	+/-0.010	1.089				
Ø0.734	±0.010 ^{+0.010} -0.010	.736				
2.658	+/-0.010	2.657				
1.550	+/-0.010	1.547				
0.125 x 45°	+/-0.010	.125 x 45°				
1.50	+/-0.030	1.490				
0.750	+/-0.010	.754				
Ø1.050	+/-0.010	1.050				
Ø1.000	+/-0.010	.999				
0.338	+/-0.010	.337				
0.563	+/-0.010	.563				
0.100	+0.000/-0.010	.0994				
3.00	+/-0.030	3.00				
1.500	+/-0.010	1.500				
0.375	+/-0.010	.381				
1.25	+/-0.030	1.240				
0.125	+/-0.010	.125				
30°	0.5°	30°				

Measured by: Rq	Audited by: JH	Prototype Approval:	N/A
Date: 05/11/03	Date: 08/11/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	

DART

DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]
05/03/09D2728-7
LABEL (1)**BATTERY LOCK SHOWN
LOCKED WITH KEY**POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWND3373-1
CAM LOCK
ASSEMBLY (1)D3393-1
CASING (1)Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) 2
AND APPLY KRAZY GLUE0.09 +0.03
-0.01 (2 PLACES)D3393-3 CAM
LOCK SHAFT (1)TACK WELD
D3393-3 TO D3369-5**SECTION A-A****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

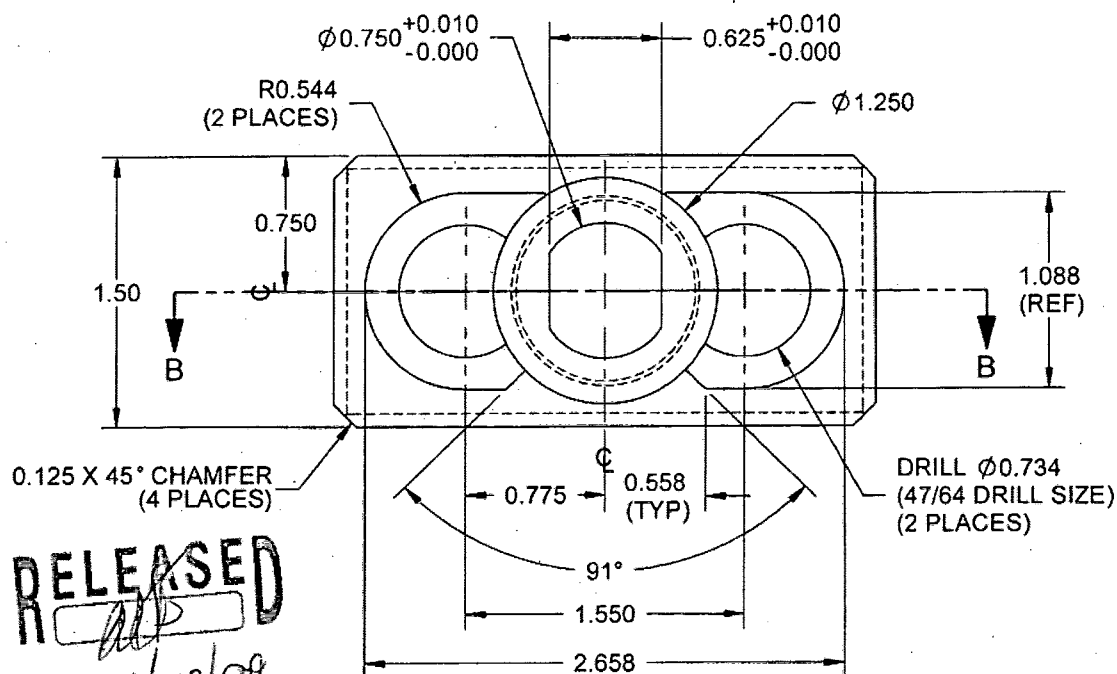
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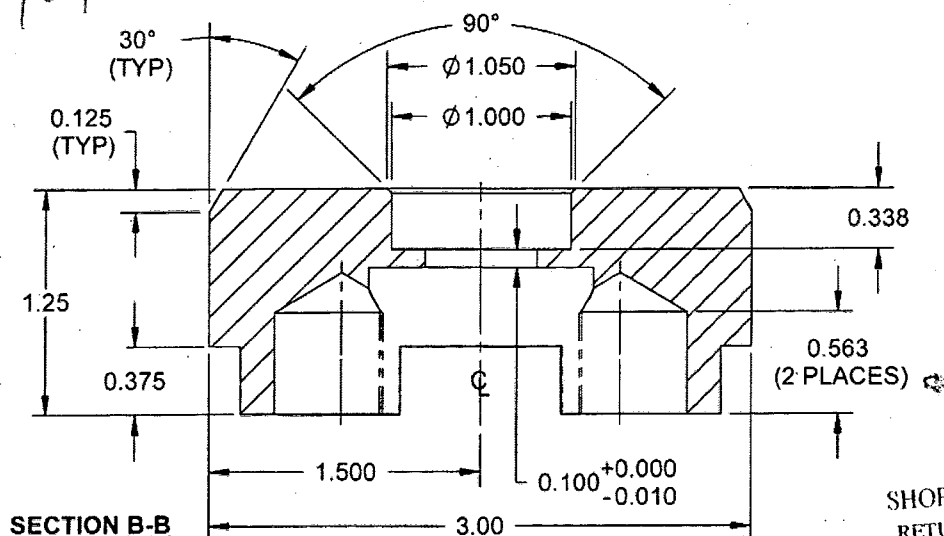
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DART

DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



RELEASED
05/03/09

**SECTION B-B****D3393-1 CASING****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

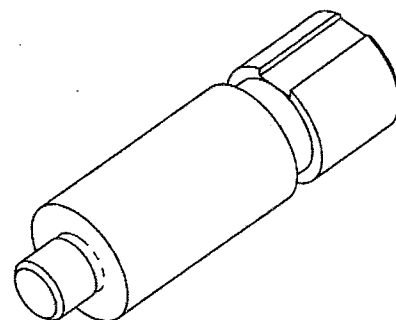
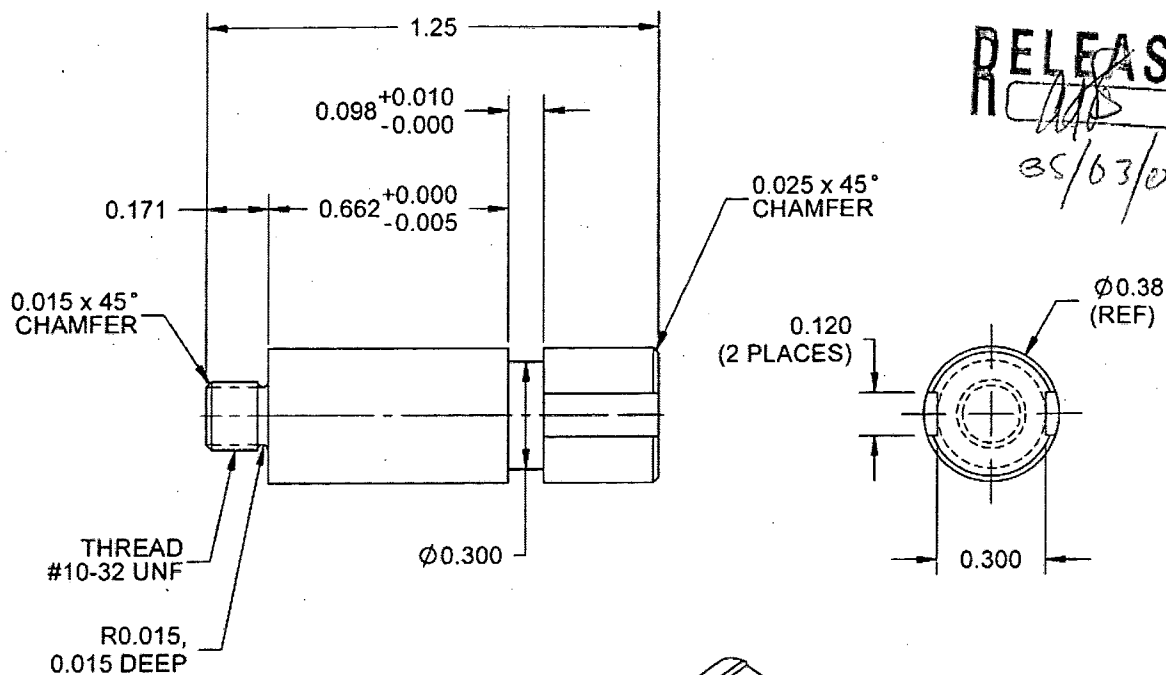
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CHECKED JF	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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